

Work Order ID 151994

Friday, October 14, 2016 1:56:44 PM

151994

Page 1

Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Outside RH
Start Date: 10/31/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/4/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: OCT 17 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3883	D
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100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

MemoProgram Batch No. 151994Double check by mont

1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets

0.18

0.44

DAS
44
9-89

12 0 16-11-01

DAS
20
9-89

16-11-05

110

110

QC

Quality Control

QC1- Inspection performed by CMM

Memo

Inspect on CMM as per folio CMMA013.

DWG REV: _____

CMM PROG. REV: _____

0.00

0.01

DAS
44
9-89

12 0 16-11-01

DAS
20
9-89

16-11-05

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Saddle, Outside RH

Start Date: 10/31/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 11/4/2016 **Req'd Qty:** 4.00 ****A****

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/
Run Hours**Tool ID**

Tool #	Plan Code
--------	-----------

Accept	Qty
--------	-----

Reject
Qty

Reject Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.08

Hand Finishing

21x



2016/11/07

БЕБ.

Work Order ID 151994

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Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outside RH
 Start Date: 10/31/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/4/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo <i>NB4798</i>	0.02							<i>12 φ. 10 11-7. 333</i>
Powder Coating	***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)*** ***DO NOT MASK INSIDE FLANGE SURFACE*** START TIME: <i>3:10</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>4:0</i>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.01							<i>12</i>
Quality Control									<i>DAS 38 9-89</i> NOV 08 2016

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Item ID: D3883-2 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle, Outside RH
Start Date: 10/31/2016 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 11/4/2016 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>Styol</u>	0.00							
160									
Packaging	Memo	0.01				12			DAS 6 9-89
Packaging									NOV 0 9 2016
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.07							16/11/9 JJ
Quality Control									

DAS
21
9-89

NOV 0 9 2016

Picklist Print

Friday, October 14, 2016 1:56:43 PM

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Work Order ID: 151994

151994

Parent Item: D3883-2

D3883-2

Parent Item Name: Saddle, Outside RH

Start Date: 10/31/2016

Required Date: 11/4/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015		Manufactured	No				Each	39.0000		4			
D6101-015									**	DAS	44		
Saddle Billet										9-89		11-01	

Location

Loc Qty

Loc Code

MAT045

39

*144955

9

150665

10

151161

20

9

3

DART AEROSPACE LTD		Work Order:	151994
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658	.515	.644	.648	.646	.645		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625	.486	.613	.615	.613	.612		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		.149	.150	.150	.149		
K	0.240	0.260		.252	.249	.249	.249		
L	0.115	0.135		.123	.124	.124	.124		
M	0.140	0.165		.147	.150	.150	.151		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.255	.254	.255	.255		
P	0.110	0.140	.135	.135	.135	.135	.135		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.855	2.855	2.855	2.855		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.000	1.000	1.000	1.000		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.002	6.001	6.001	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.500	.498	.500	.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.314	.314	.314	.314		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.761	.761	.761	.761		
AD	0.215	0.220		.220	.219	.219	.217		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject				/	/	/			

Measured by: 44	Audited by: DAS
Date: 16-11-01	Date: 16/11/06

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	151994
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.645	.643	.643	.643		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.611	.611	.608	.610		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		.149	.148	.149	.151		
K	0.240	0.260		.248	.248	.249	.250		
L	0.115	0.135		.124	.123	.122	.122		
M	0.140	0.165		.151	.149	.147	.147		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.255	.255	.254	.255		
P	0.110	0.140		.135	.135	.135	.135		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.855	2.855	2.855	2.855		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.000	.999	.998	.998		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.001	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.498	.500	.498	.498		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.314	.314	.314	.314		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.761	.761	.761	.761		
AD	0.215	0.220		.217	.219	.219	.219		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject									

Measured by: 44	Audited by: 49
Date: 16-11-02	Date: 16/11/06

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	151994
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883 Rev. D		Page 1 of 1	

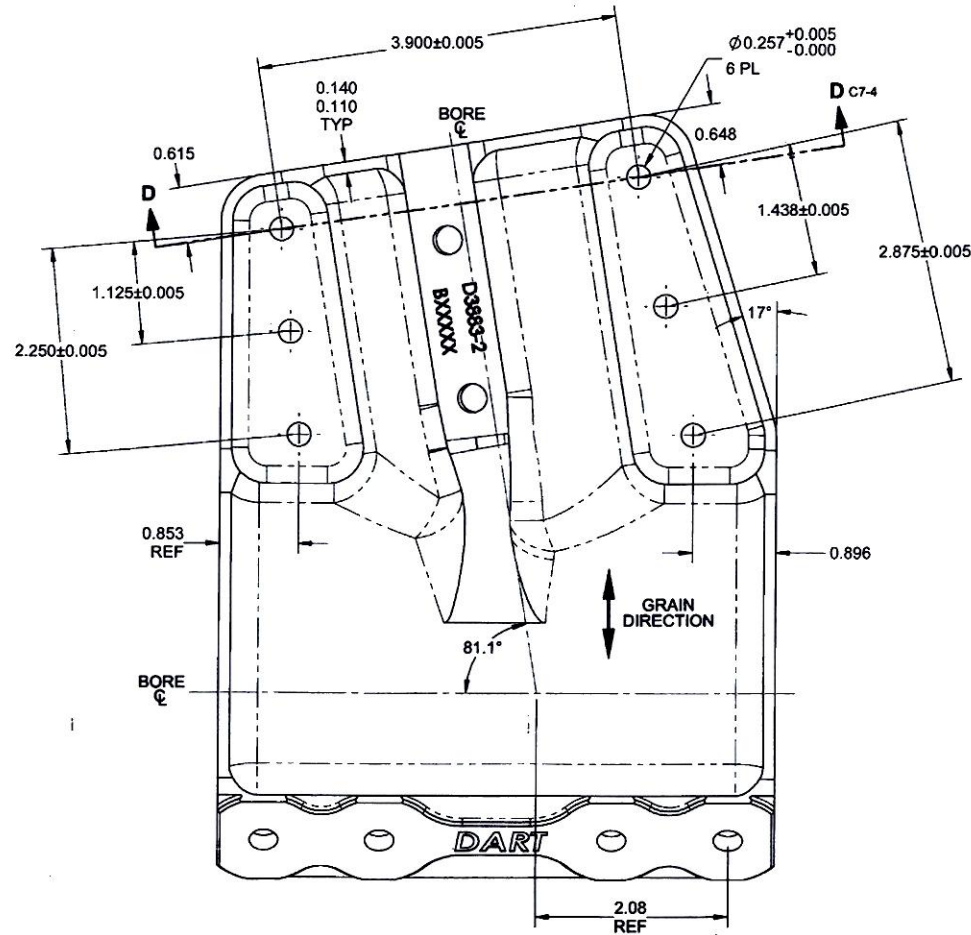
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.643	.645	.644	.645		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.609	.611	.611	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		.148	.151	.151	.149		
K	0.240	0.260		.248	.248	.250	.247		
L	0.115	0.135		.127	.123	.123	.124		
M	0.140	0.165		.149	.148	.149	.148		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.255	.255	.255	.251		
P	0.110	0.140		.140	.140	.140	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.855	2.855	2.855	2.855		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		.998	.998	1.000	.999		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.496	.497	.502	.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.314	.314	.314	.314		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.761	.761	.761	.761		
AD	0.215	0.220		.218	.219	.218	.219		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject									

Measured by:	20 9-89
Date:	16-11-05

Audited by:	DAS
Date:	49 16/11/06 9-89

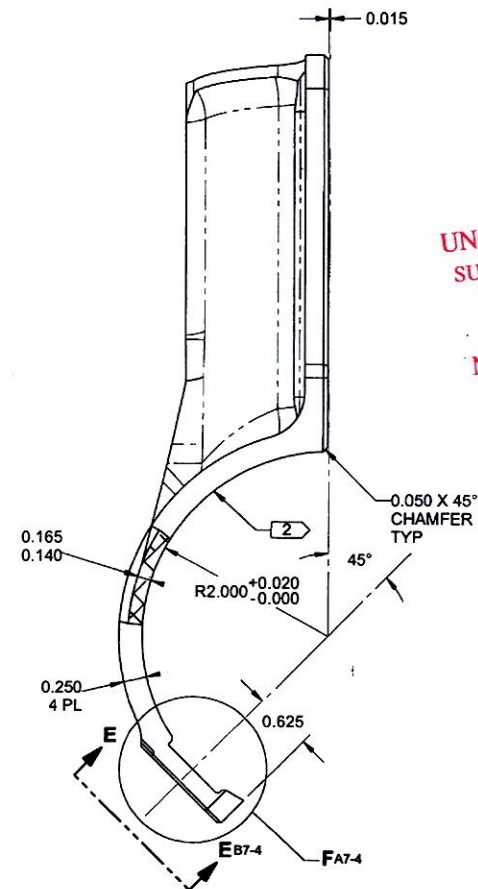
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	



D3883-2 SADDLE, OUTBOARD RH

NOTES:

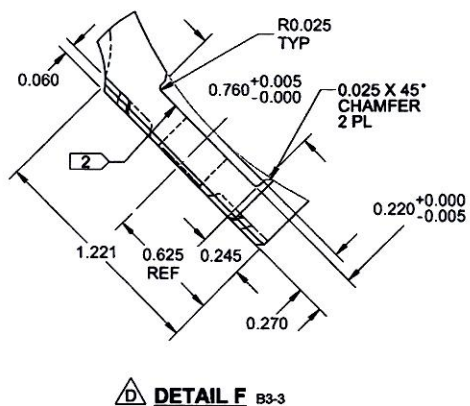
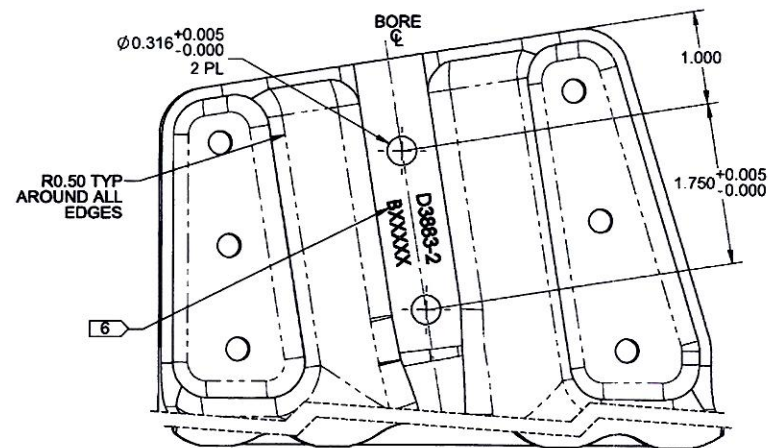
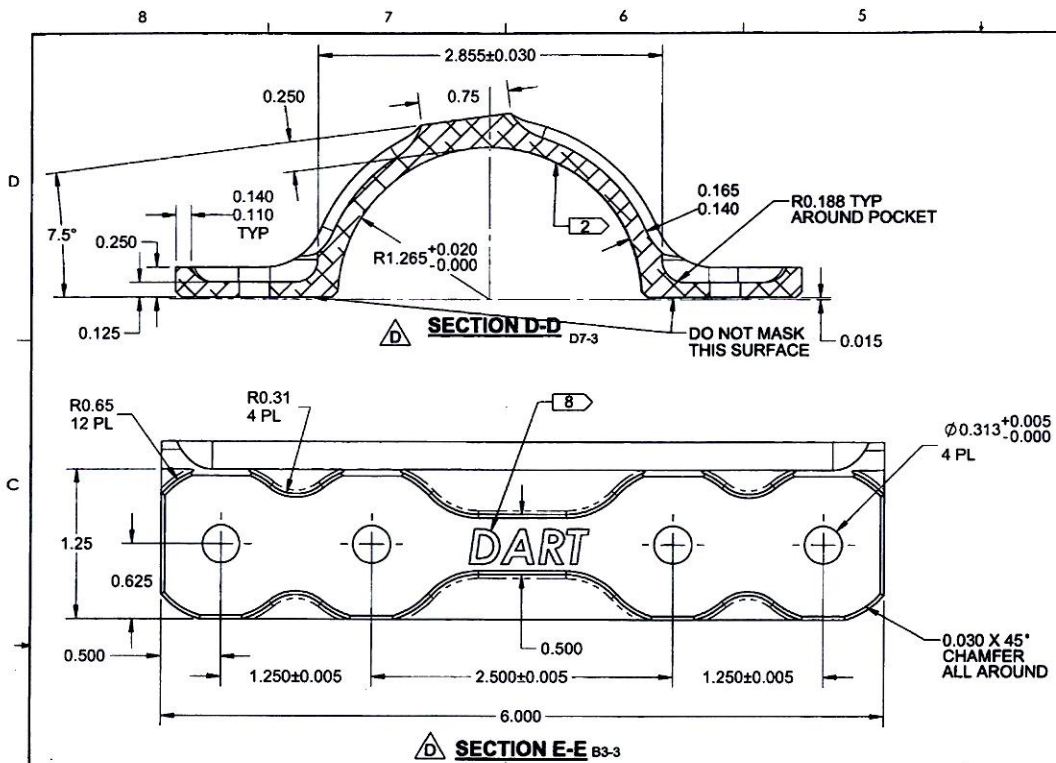
- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REV.D.SLDPRT"



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151994M5
1670-17

RELEASED
APR 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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